

ABSTRACT

This invention mainly develops the multiple discharge-servo curve control method and device of electrical discharge machine. It comprises a storage unit, a setting unit, a reading unit, a program
5 unit and instruction-judging unit. Herein the operator can dominate the program execution by using program calling method, and calls a discharge-servo curve instruction to satisfy with the real machining requirement. In order to achieve one-step processing with selectable multiple discharge-servo curve, this will swaps the discharge-servo
10 curve from a system calling to a program calling.